

Date: Friday, 1/25/2008 11:19:05 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKIDTUBE ASSEMBLY
Job Number : 36990A
Estimate Number : 10309
P.O. Number :
This Issue : 1/25/2008 S.O. No. :
Prsht Rev. : NC Part Number : D206642541
First Issue : / / Type : LANDING GEAR Drawing Number : D3274 REV D
Previous Run : 36989A Drawing Revision : D
Material :
Due Date : 3/10/2008 Qty: 1 Um: Each
Written By :
Checked & Approved By :
Comment : Est Rev:B 05-09-23 Revised per D206-642 Rev. J KJ/JLM
Est Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
Est Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D206-642-541 CHG003 N/A

2.0 D26001190 Extrusion Round 3" 206



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch
1 D2600-1-190 3" OD Tube 31032 SL 8-1-28

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-1 to 190.00" in length as per Dwg D3274 and Deburr ends

2-Drill #40 Aft cap pilot hole using DT8025

3-Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274

4-Remove inner indexing ridge on aft end of skidtube as per Dwg D3274

5-Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

SL 8-1-28

3-1-28

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description:

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid Etch and Alodine tube as per QSI 005 4.1

SL 8-1-28

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Q. n 08-01-29 (9)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/29 (K)

7.0

D3282041

I-Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3282-041 Float Web

37052 SL 8-3-4

8.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open Ø0.313" crossbolt spacer holes using DT8743 as per Dwg D3274

2-Open Ø0.375" crossbolt spacer holes using DT8744 as per Dwg D3274

3-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube

4-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291

Sikaflex expire date:

Start: 8-3-4

Finish: 05/03/05

(Adhere for 12 hours)

Time: 7:30

Time: 10:20 AM

SL 8-3-4

K
8-1-29

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

05/03/05 (K)

W/O:		WORK ORDER CHANGES					
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Job Number: 36990A

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Job Number:



Seq. #:

Machine Or Operation:

Description:

10.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Bend tube using program D3274 as per Dwg D3274. Install drop pins in cross bolt spacer holes to maintain web position.

2-Cut Fwd end of tube to length as per Dwg D3274

*****Verify dimensions before and after cutting*****

3-Remove inner indexing ridge on Fwd end of skidtube as per Dwg D3274

4- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297"

5-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE
DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)
REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

6- Countersink crossbolt spacer holes as per Dwg D3274

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

12.0

D32851

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3285-1

Fwd Cap

23902

BE 08/03/14

13.0

D2649

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number

Description Batch

12 D2649

Crossbolt spacer

236013

BE 08/03/14

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description:

14.0

D32751

Crossbolt Spacer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 D3275-1 Crossbolt spacer

B34619 BE 08/03/14

15.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld Fwd Cap as per Dwg D3274 and QSI 004. Use aluminum rod.

A/R Aluminum Rod *m106330/m106762 BE 08/03/14*

2-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod *m106330 BE 08/03/14*

3-Grind welds flush to Fwd cap on top surface only.

A.m 08.03.17 ①

4-Grind cross bolt welds flush as per Dwg D3274. Masking Tape access to inside of the skidtube

A.m 08.03.17 ①

5-Counterbore 5/16" x 0.750" deep as per Dwg D3274. Use DT8743 visual aid Jig and deburr.

A.m 08.03.17 ①

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/03/18 ①

17.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

D 08-03-18 ①

18.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

m-l 08/03/25

19.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l 08/03/25

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Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-03-26

(X1)

21.0

D3415041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3415-041 Nut Plate B33842

9.1

22.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CCR264SS3-3 Rivet M106825

9.1

23.0

CR3212403

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 CR3212-4-03 Rivet M15918

9.1

24.0

ALS71032130

Insert



Comment: Qty.: 78.0000 Each(s)/Unit Total: 78.0000 Each(s)

Insert

Batch: M105854 * 9.1

25.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install Nut Plate as per Dwg D3274. Apply LPS-3 to Nut Plate and rivets.

LA/RN/ALPS-3 M104251

2-Install inserts as per Dwg D3274. Use a drop of Sikaflex inside insert holes a

9.1

08-03-26

(X1)

W/O:		WORK ORDER CHANGES					
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Job Number: 36990A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description:

A/R Sikaflex-291 M105585
Sikaflex expire date: 08-07

JP 08-03-26 (X)

26.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP
Inspect Nut Plate & Inserts

JP 08/03/26 (X)

27.0

AN3C4A

BOLT



Comment: Qty.: 80.0000 Each(s)/Unit Total: 80.0000 Each(s)
BOLT
Batch: M107534

JP

28.0

D353515

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B336653

JP

29.0

D353523

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B35218

JP

30.0

D353535

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B36425

JP

31.0

D353539

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEARSHOE
Batch: B37277

JP

32.0

D353615

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
GASKET
Batch: B33964

JP

08-02-21 (X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Job Number: 36990A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

33.0

D353623

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: 1333965 JS

34.0

D353635

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: 1337352 JS

35.0

D353639

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
GASKET
Batch: 1333966 JS

36.0

D35371

WEARPAD



Comment: Qty.: 9.0000 Each(s)/Unit Total : 9.0000 Each(s)
WEARPAD
Batch: 1337292 JS

37.0

D35373

WEARPAD



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
WEARPAD 1333881 JS

38.0

AN960C10L

washer



Comment: Qty.: 80.0000 Each(s)/Unit Total : 80.0000 Each(s)
Pick:
Qty Part Number Description Batch
80 AN960C10L Washer 11107008 JS

39.0

D36721

PHENOLIC WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer
batch 1334470 JS 08-03-26 (XV)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Drawing Name: FLOAT SKIDTUBE ASSEMBLY

Job Number: 36990A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

40.0

D34131

Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3413-1 Ring B33949 91

41.0

AN4C5A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN4C5A Bolt M104936 91

42.0

AN960C416

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 AN960C416 Washer M100993 91

43.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2646 Aft Cap B36184 91

44.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

✓ 2-Install wearpads & gaskets as per Dwg D3274.

3-Install ring as per Dwg D3274

✓ A/R Sikaflex-291 M105585

Sikaflex expire date: 08-07

✓ 4-Inspect for foreign objects as per QSI 024

5-Spray inside of tube on both sides of web with LPS-3

✓ A/R LPS-3 Batch: M104251

6-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

W/O:		WORK ORDER CHANGES					
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Job Number: 36990A

Part Number: D206642541

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291 M105585
Sikaflex expire date: 08-07

JSB 08-03-31 (X)

45.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

608/03/31 (X)

46.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: VP B36990

AS 08/03/01 (X)

47.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/02 JSB

Job Completion



W 08-04-02

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

RELEASED07.02.12 **[Signature]**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

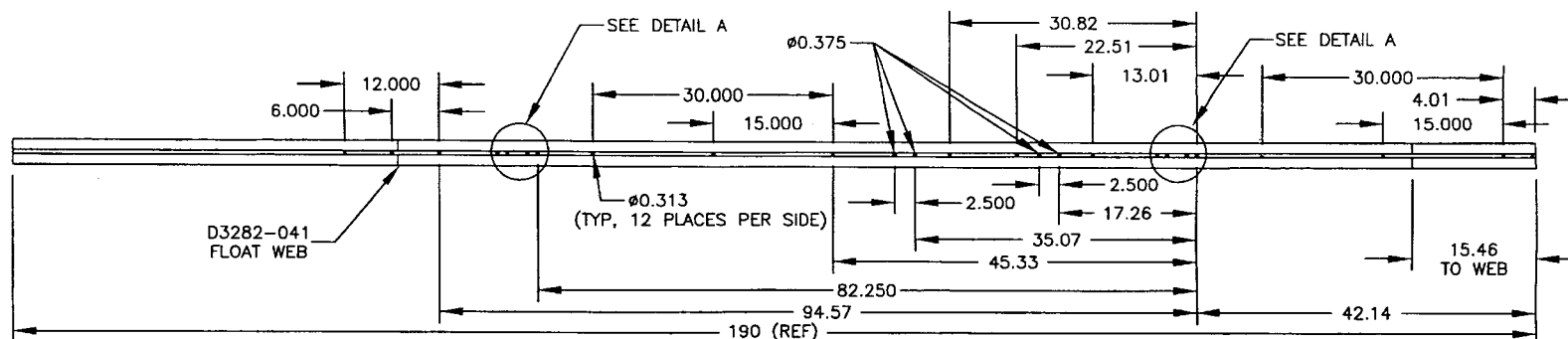
1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT

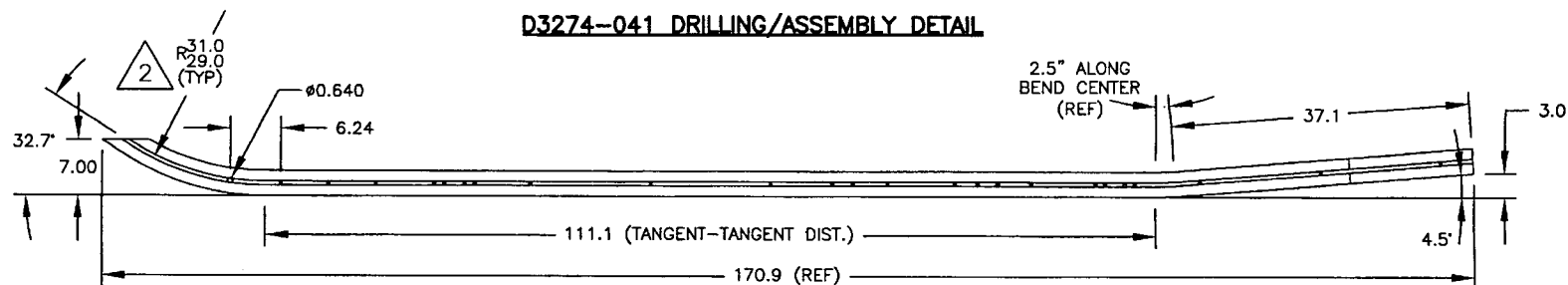
WITHOUT NOTICE

WORK ORDER
NO. 36990A**Copyright © 2004 by DART AEROSPACE USA, INC.**

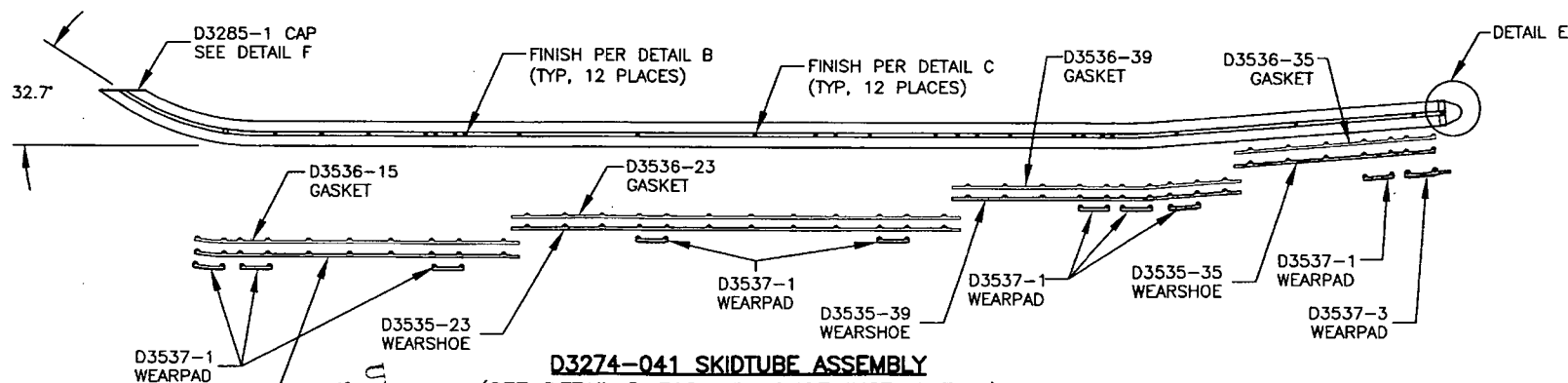
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D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

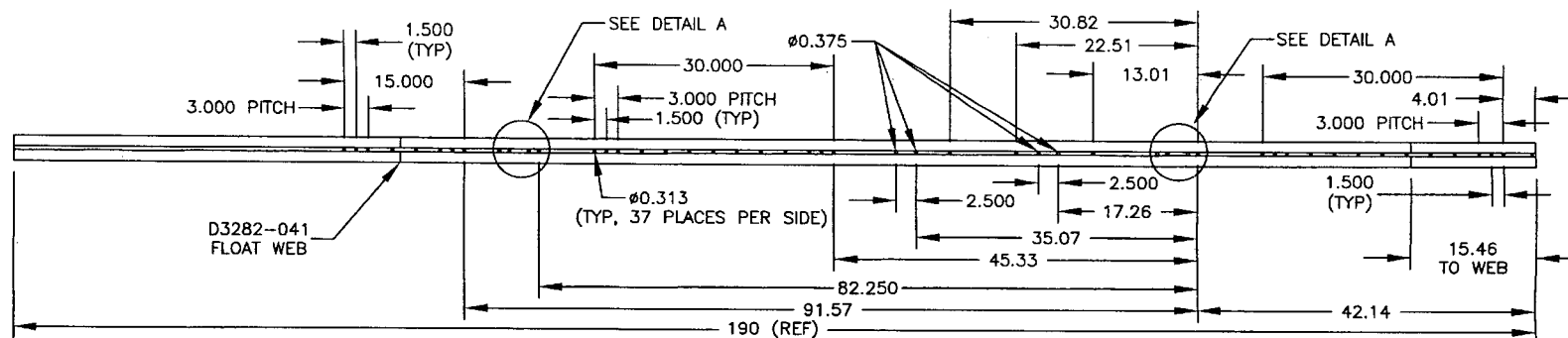
07.02.12

NO. 369904
WORK ORDER
SUBJECT TO AMENDMENT
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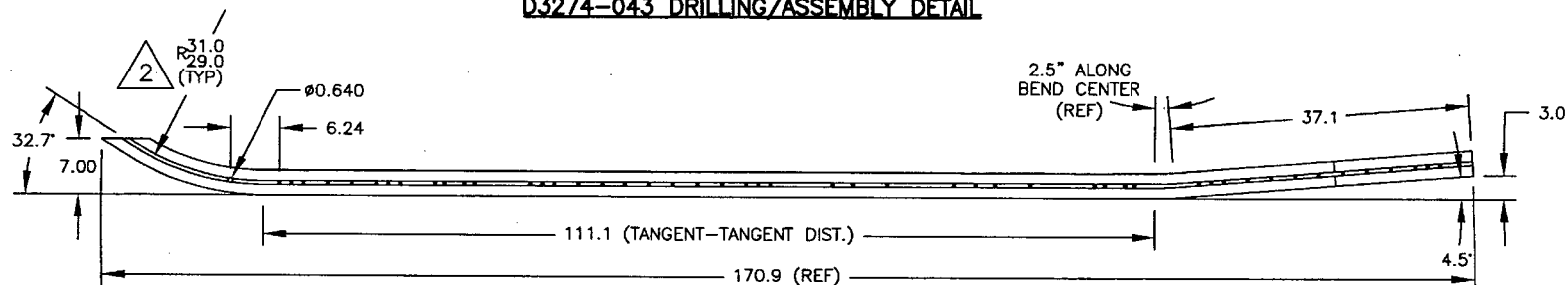
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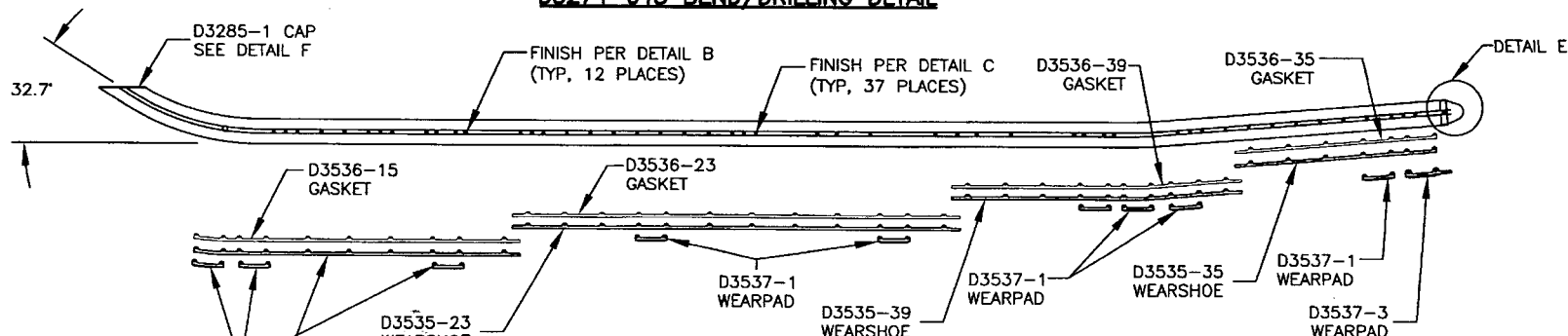
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CHECKED	#	APPROVED	#	DRAWING NO. D3274	SHEET 2 OF 4
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	SCALE	1:15



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

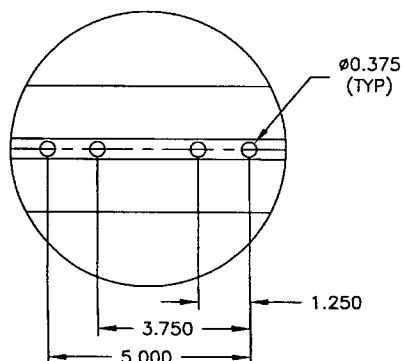
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07.02.12

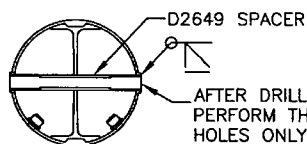
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		DATE	06.12.19		TITLE SKIDTUBE ASSEMBLY		SCALE 1:15

DETAIL A: DRILL DETAIL

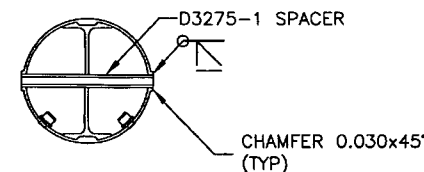


DETAIL B FOR 0.375 HOLES ONLY

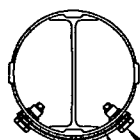


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO 0.313x0.75 DEEP

DETAIL C FOR 0.313 HOLES ONLY

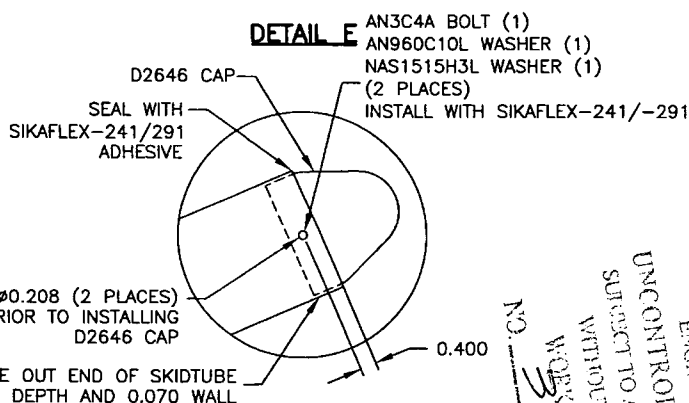


DETAIL D

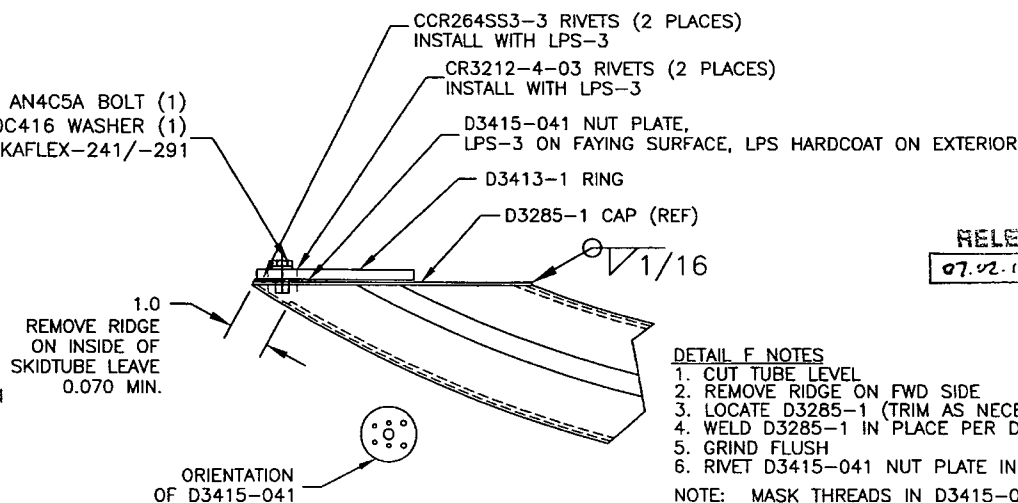


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RELEASED
07.02.12

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		DATE	06.12.19			TITLE SKIDTUBE ASSEMBLY	SHEET 4 OF 4 SCALE 1:3

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AWS D17.1.2001
QUALIFICATION TEST RECORD

Name Bardley E.
Joint Welding Procedure Tig
Part number and Job number 8 D206 642 541 / B36992 A

TEST WELDS REQUIRED

BASE METAL Aluminum
Penetration Complete ☐ Partial ☒
Current AC ☒ DC ☐

WELDING PROCESS Tig
Single Weld ☒ Double Weld ☐
Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input checked="" type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

TEST RESULTS

Visual Pass ☒ Fail ☐
Penetration Pass ☒ Fail ☐
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 08-03-01

Qualifier Det. Dmial